

OK 530

DART AEROSPACE LTD		Work Order:	23872
Description: Webbing Tidy		Part Number:	D3215-3
Dwg: D3215 Rev. A page 3 04.03.24		Qty:	62 62 62
		Page 1 of 1	

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Note: To be made in multiples of 10.	AL	05/07/28	60
2	MV	Cut blank: 2.562" x 0.880", Grain along 2.562" Material: 5052-H32 (QQ-A-250/8) 0.040" thick PF 04.01.12 (M5052H32S.040) Identify for D3215-3A Batch: <u>M12835</u>	BSG	05.08.02	70
3	MV	Machine D3215-3A as per Folio FA376 and dimensions Use Stack of 10 Identify as D3215-3A	BSG	05.08.03	70
4	QC2	Inspect parts as they come off the CNC machine	BSG	05.08.03	70
5	MV	Deburr for measurement	BSG	05.08.03	70
6	QC8	Second check	BSG	05.08.03	70
7	GA	Cut blank: 2.130" x 0.530" Material: 5052-H32 (QQ-A-250/8) 0.040" thick (M5052H32S.040) Identify as D3215-3B Batch: <u>M18019</u>	BSG	05.08.02	70
8	GA	Deburr D3215-3A/-3B	SAD	05/08/04	70
9	GA	Form D3215-3A as per Dwg D3215	2	05.08.05	70
10	QC5	Inspect work to Step 9	MA	05/08/05	70
11	WA	Weld D3215-3 by joining D3215-3A and D3215-3B as per Dwg D3215 and QSI 004 Identify as D3215-3	OPL	05/08/08	70
12	WA	Grind flush	CPC	05/08/08	70
13	QC9	Inspect weld	PD	05.08.09	62
14	FP	Chemical Conversion Coat as per QSI 005 4.1	MM	05 08 10	62
15	FP	Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3	FC	05 08 09	62
16	QC3	Inspect Powder Coat	MM	05 08 10	62
17	ST	Identify and Stock	CL	05/08/10	62
18	AC	Cost / part <u>7.97</u>	SAC	05.08.02	62
19	DC	Close W/O <u>7.97</u> Inspect Level 21	SA	05/08/11	62

Rev	Date	Change	Revised By	Approved
A	04.01.06	New issue	KJ/RF	RF

RELEASED
04.01.09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: *LD* Date: 05/08/11

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

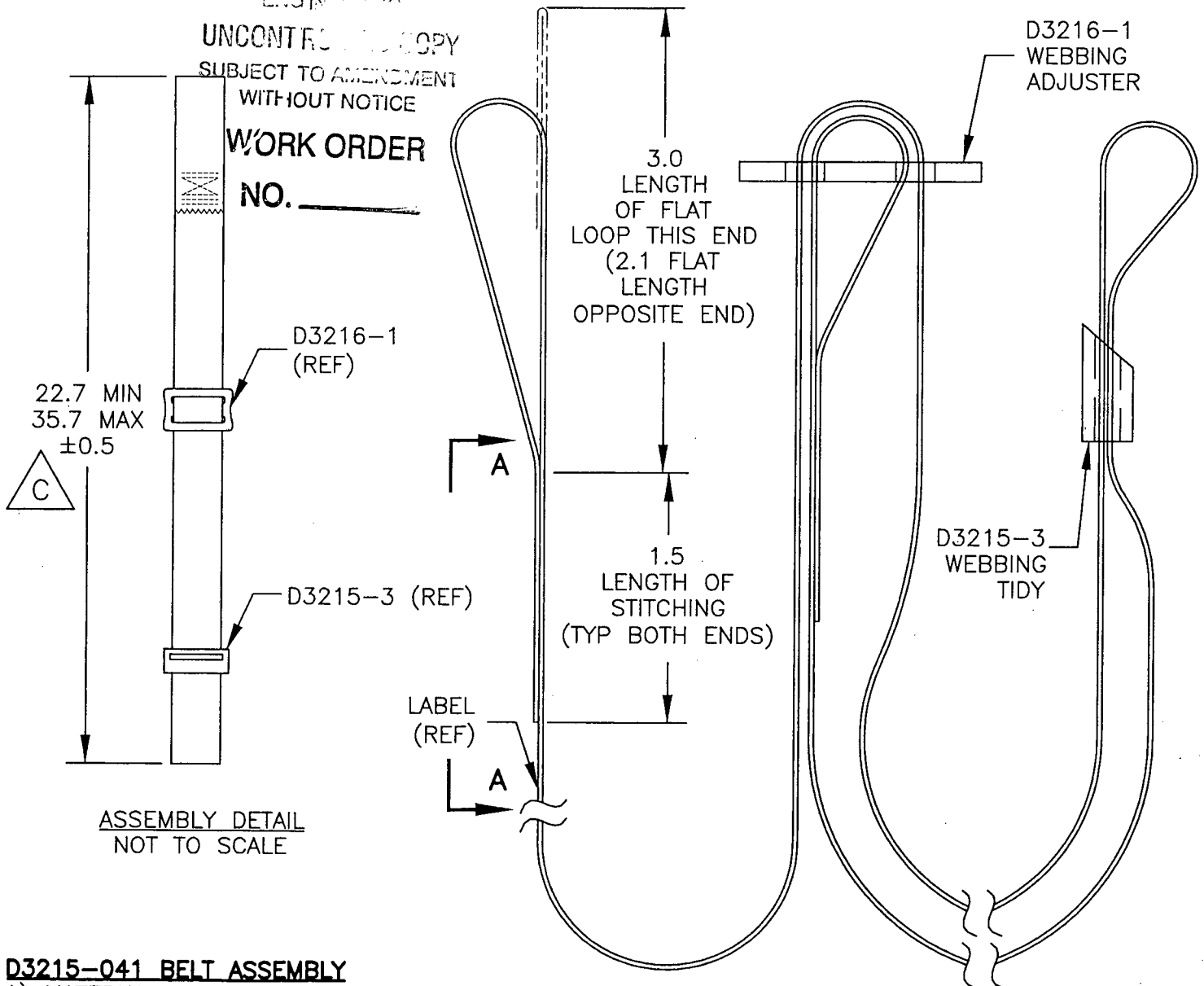


DESIGN	<i>Q</i>	DRAWN BY	<i>Q</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. C
CHECKED	<i>#</i>	APPROVED	<i>#</i>	DRAWING NO. D3215	SHEET 1 OF 3
DATE	04.03.05	TITLE	BELT ASSEMBLY	SCALE	NTS
A	03.09.19	NEW ISSUE			
B	04.01.12	AS MANUFACTURED; ADD TOLERANCE			
C	04.03.05	REDUCE LENGTH; CLARIFY STITCHING			

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WORK ORDER
NO. _____



D3215-041 BELT ASSEMBLY

- 1) MATERIAL: WEBBING = LAGRAN CANADA INC. 26472
(2" WIDE x 0.060" THICK BLACK POLYESTER WEBBING, CERTIFIED TO FAR 29.853A3, TENSILE STRENGTH 5700 lb MIN)
THREAD = VT 295 TYPE II CLASS A SIZE 3, BLACK NYLON THREAD
LABEL = TYVEK
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3215	REV. C SHEET 3 OF 3
DATE 04.03.05	TITLE HARNESS ASSEMBLY		SCALE 1:1

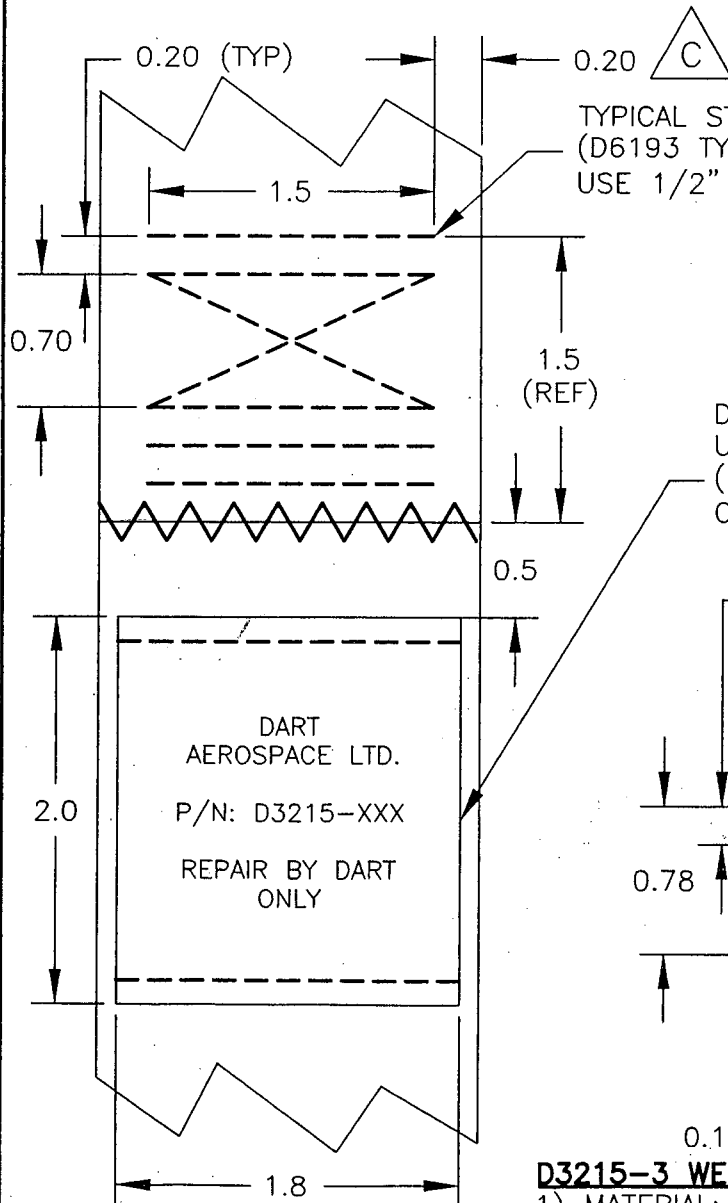
VIEW A-A

XXX = 041 FOR D3215-041
XXX = 043 FOR D3215-043

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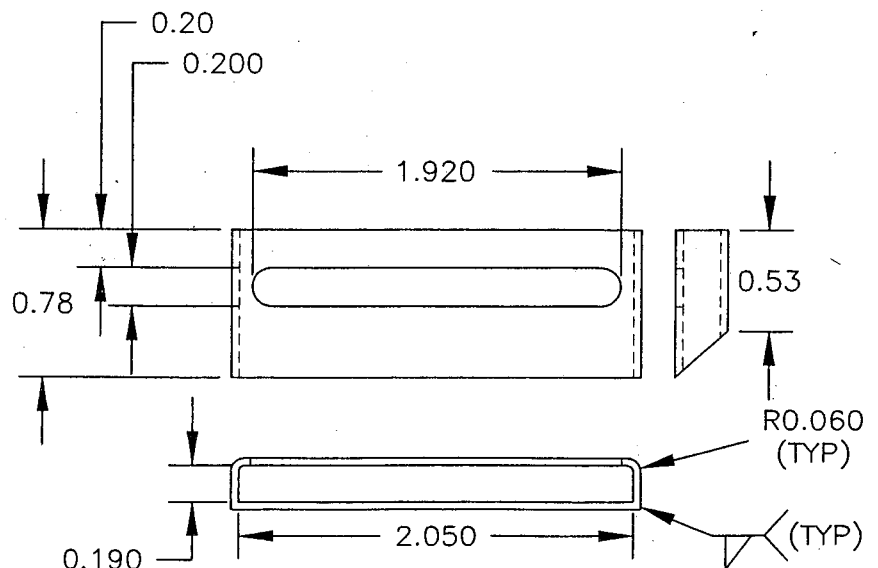
WORK ORDER

NO. _____



TYPICAL STITCHING PATTERN
(D6193 TYPE 301, 7-10 STITCHES PER IN.
USE 1/2" MIN. BACKSTITCH, NO LOOSE THREADS)

D3215-1 LABEL
USE 1/8" BLACK LETTERING
(INSTALLED ON ONE END ONLY,
CENTER ON BELT)



D3215-3 WEBBING TIDY

- 1) MATERIAL: 5052-H32 ALUMINUM SHEET, 0.040" THICK
(REF DART SPEC. M5052H32S.040)
- 2) WELD PER DART QSI 004
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER
DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE
NOTED

RELEASED
04.03.05